



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

ASAP

D5159-1

Job Sheet 180680



Part No: D5159-1

Job Qty: 1 ea

Part Name: Rib



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/12/18

Job Tracking No:

Due Date: 7/12/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV A IPP REV:A 14.10.03 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		7/12/18	0.00	0.00	Start Up Machining-4		DAS
110	Cold Saw	1 pcs		7/12/18	0.00	0.16	Cold Saw		56
120	Mill Conv	1 pcs		7/12/18	0.00	1.37	Mill Conv 1		9.89
130	QC	1 pcs		7/12/18	0.00	0.00	QC2 Machining-3		
140	QC	1 pcs		7/12/18	0.00	0.00	QC8 Machining-3		
150	Powdercoat	1 pcs		7/12/18	0.00	0.02	Powdercoat3		
160	QC	1 pcs		7/12/18	0.00	0.00	QC3		
170	Packaging	1 pcs		7/12/18	0.00	0.00	Packaging3-2		
180	QC21-SA	1 Ea		7/12/18	0.00	0.00	QC21		

Part Op 110 - CUT TO BLANK

Descriptions: 120 - DRILL HOLES AND MILL ENDS AS PER DWG ***ENSURE MATERIAL SEAM IS AT THE BOTTOM OF THE PART

WHERE THERE IS NO HOLES***

150 - START TIME: *1:35 O.T. 300° FINISH : 2:05-*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304TS0.750W.049	304 Sq Tube .75X.75X.049W	1.2275 ft (1.2275 ea)	90-Start up Operation	<i>5055083</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304TS0.750W.049	1	342	0



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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S091221



Part: D5159-1

Job No: 180680

Serial No/Batch: S091221

Revision:

Inspector:

Exp Date:

Instructions:

Date: 07/12/18

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐	

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rib	14.700Inches ± 0.030	14.730 14.670		
2	Rib	12.790Inches ± 0.030	12.820 12.760		
3	Rib	0.950Inches ± 0.010	0.960 0.940		
4	Rib	0.266Inches ± 0.010	0.276 0.256		
5	Rib	0.297Inches ± 0.010	0.307 0.287		
6	Rib	0.400Inches ± 0.030	0.430 0.370		
7	Rib	1.000Inches ± 0.010	1.010 0.990		
8	Rib	3.000Inches ± 0.010	3.010 2.990		
9	Rib	2.000Inches ± 0.010	2.010 1.990		
10	Rib	2.000Inches ± 0.010	2.010 1.990		
11	Rib	3.000Inches ± 0.010	3.010 2.990		
12	Rib	1.000Inches ± 0.010	1.010 0.990		
13	Rib	0.129Inches + 0.005 - 0.001	0.134 0.128		
14	Rib	2.440Inches ± 0.030	2.470 2.410		
15	Rib	2.625Inches ± 0.010	2.635 2.615		
16	Rib	0.129Inches + 0.005 - 0.001	0.134 0.128		
17	Rib	0.350Inches ± 0.030	0.380 0.320	Radius	

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Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
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Description Work Order Deviation 	Disposition 	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause Environment ☐ No Re-verification ☐ Design ☐ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Temperature/Cure ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Bending ☐ Set-up ☐ Folio/Program ☐ Outside Dimensions ☐ Centre Not Concentric ☐ BOM/Route ☐ Grain ☐ Over/Under tolerance ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Part Incorrect ☐ Crimp/Kink/Ripple/Wave ☐ Inspection Incomplete/Unqualified ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Cuffs ☐ Contamination ☐ Out of Sequence ☐ Part Moved ☐ Crushing ☐ Countersink ☐ Off-set ☐ Drawing ☐ Heat Treat ☐ Cut Too Short ☐ Misabeled ☐ Finish ☐ Wave/Twist in Tube ☐ Instructions Incomplete/Unclear ☐ Fit/Function ☐ Misread ☐ Marks/Chatter ☐ Drill Holes ☐ Misaligned/off center ☐ Turning Sequence ☐		
OTHER : ☐					